

Work Order ID 52932

October 19, 2009 11:01:47 AM

Page 1

Item ID: D3968-3

Accept

Revision ID: A

Item Name: Backing Plate, Airframe Hinge

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *RR*

Date: *04-10-19* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3968	A								

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3968

Dwg Rev: *A*

Prog Rev: *A*

2-Debur if necessary

= 7 m-l 09/11/02

16X

16

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

18 9-10-09

Work Order ID 52932

October 19, 2009 11:01:47 AM

Page 2

Item ID: D3968-3

Accept

Setup Start

Revision ID: A

Stop

Item Name: Backiing Plate, Airframe Hinge

Start Date: 10/19/09 Start Qty: 8.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 8.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M112148

START: 7:30AM

Temp = 320°F

FIN: 8:00AM

2> Sorkul02

BK 09-11-3

M 09/11/3

(16)

(16)

(16)

Work Order ID 52932

October 19, 2009 11:01:47 AM

Page 3

Item ID: D3968-3

Accept

Revision ID: A

Item Name: Backiing Plate, Airframe Hinge

Start Date: 10/19/09 Start Qty: 8.00

Required Date: 11/02/09 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 137

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



09/11/04

09/11/04

09-11-4

Picklist Print

October 19, 2009 11:01:51 AM

Page 1

Work Order ID: 52932

Parent Item: D3968-3A-PRELIM

Parent Item Name: Backiing Plate, Airframe Hinge

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	105.0952	0.1263	3000		

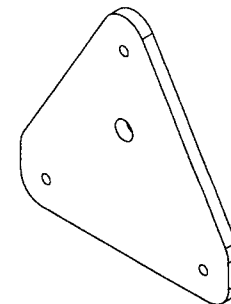
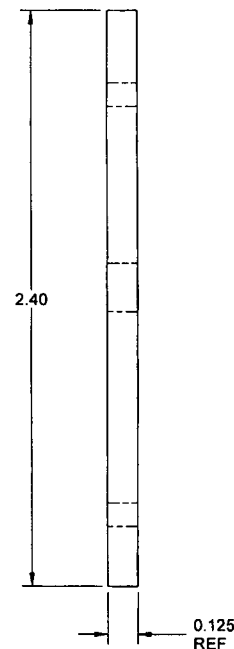
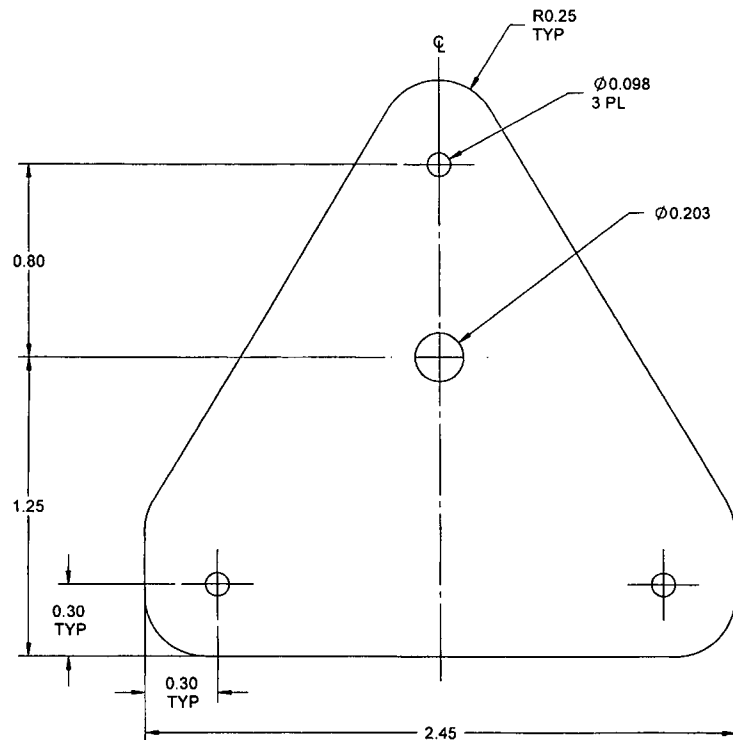


6061-T6 .125 Sheet

B9-10-28

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	105.0952	
110062	1.85	
111642	19.592	
112476	32	
112567	51.6532	

112567



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WITHOUT NOTICE
WORK ORDER
NO. 52932

PR 09-10-19

D3968-1 BACKING PLATE, GAS SPRING

RELEASED
2009-10-08
MD

NOTES:

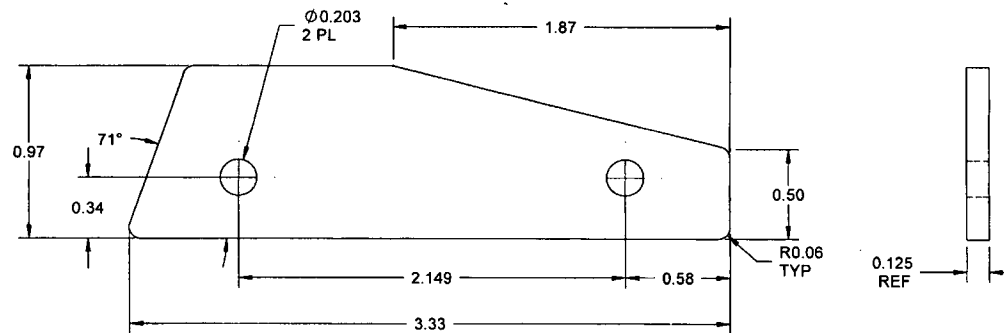
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027 OR AMS 4025
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3968-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>		
DRAWN	<i>AS</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>2/1</i>		
APPROVED	<i>MD</i>		
DE APPR.	<i>MD</i>		
DATE	09.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3968** REV. A
SHEET 1 OF 2
TITLE **BACKING PLATE** SCALE NTS

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WITHOUT NOTICE
WORK ORDER
NO. 52932

D3968-3 BACKING PLATE, AIRFRAME HINGE

RELEASED
2009-10-08
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4027 OR AMS 4025
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3968-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	AE	DART AEROSPACE LTD	
DRAWN	AE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3968	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BACKING PLATE	NTS
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